Applies To: **Models Without Sidewinder-Type Ignition Keys** – ALL

May 13, 2003

Cutting Keys With the Exacta Key Code Cutter

(Supersedes 88-012, dated April 20, 1999)

The Exacta Key Code Cutter is a portable, hand-operated tool that cuts original automotive keys by code. The key cutter has these features:

- Is completely portable; needs no electricity
- Updates easily by changing four parts
- Has an extended 5-year warranty through the Honda Tool and Equipment Program

The Exacta Key Code Cutter cuts standard Honda key blanks (nonimmobilizer and immobilizer types) as well as Ilco programmable key blanks (**T5** stamped on the shank). *It cannot cut sidewinder-type keys.* If you need to cut sidewinder-type keys, refer to S/B 01-077, *Cutting Sidewinder-Type Keys With the MATRIX H Key Cutting Machine*.

With Ilco programmable key blanks (see **PARTS INFORMATION**) and the Ilco Immobilizer Key Code Duplicator, you can duplicate a programmed ignition key. Refer to S/B 99-053, *Ilco Immobilizer Key Code Duplicator*, for details.

This service bulletin tells you how to order the key cutter, accessory kits, replacement parts, and key blanks. It guides you through the entire key cutting process from setting up the key cutter to cutting the key blank.

TOOL INFORMATION

Exacta Honda Master Key Code Cutter Kit:
Model No. ILCMK1COMP

Exacta Honda Master Key Code 3001–4481 Cutter Accessory Kit A:
Model No. ILCMK1A

Exacta Honda Master Key Code 5001–8442 Cutter Accessory Kit B:
Model No. ILCMK1B

Exacta Honda Master Key Code 5001–7000 Cutter Accessory Kit C:
Model No. ILCMK1C

Exacta Honda Master Key Code 4001–6000 Cutter Accessory Kit D:
Model No. ILCMK1D

NOTE: Key blanks do not come with any of these kits. Refer to **ORDERING INFORMATION** for details.

PARTS INFORMATION

Honda Ilco Master Key Blank (10 Pack):
Model No. ILC35113T5H

Honda Ilco Valet Key Blank (10 Pack)
Model No. ILC35114T5H

ORDERING INFORMATION

Order Honda standard key blanks (nonimmobilizer and immobilizer types) through normal parts ordering channels. Refer to your *Honda Parts Reference Guide* for the appropriate key blank part numbers.

If you are ordering Honda standard immobilizer key blanks, make sure you program their transponder codes into the immobilizer system with the Honda Diagnostic System (HDS).

Order the key cutter, accessory kits, replacement parts, and Ilco programmable key blanks through the Honda Tool and Equipment Program. To place an order, call **888-424-6857**, or use the fax order form provided in your *Honda Tool and Equipment Program Catalog*. You can also order online through the Interactive Network (*i*N). Click on **Service**, **Tool and Equipment**, and then **Online Catalog**. Click on **General Shop Equipment**, **Body Tools**, and then **Key Code Cutter Kit**.

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Skill Level
R
REPAIR

CUSTOMER INFORMATION: The information in this bulletin is intended for use only by skilled technicians who have the proper tools, equipment, and training to correctly and safely maintain your vehicle. These procedures should not be attempted by "do-it-yourselfers," and you should not assume this bulletin applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Honda automobile dealer.

APPLICATION CHART

(For Use With Model No. ILCMK1COMP)

Model	Accessory Kit	Kit Contents
1982–89 Accord 1984–87 Civic 1983–91 Prelude	**Kit A** Model No. ILCMK1A (For Key Code Series 3001 to 4481)	Punch & Die Assy (45°) Model No. ILC5 Key Insert Model No. ILC130 Depth Knob Model No. ILCM Spacing Plate Model No. ILC225
1990–02 Accord 1988–02 Civic 1997–01 CR-V 2000 and later Insight 1995–02 Odyssey 1998–02 Passport 1992–01 Prelude 2000 and later S2000	**Kit B** Model No. ILCMK1B (For Key Code Series 5001 to 8442)	Punch & Die Assy (47°) Model No. ILC30 Key Insert (Master) Model No. ILC146 Key Insert (Valet) Model No. ILC151 Depth Knob Model No. ILCHD Spacing Plate Model No. ILC240
1995.5–97 Passport	**Kit C*** Model No. ILCMK1C (For Key Code Series 5001 to 7000)	Key Insert Model No. ILC152 Depth Knob Model No. ILCV Spacing Plate Model No. ILC240
1994–95 Passport	**Kit D*** Model No. ILCMK1D (For Key Code Series 4001 to 6000)	Key Insert Model No. ILC170 Depth Knob Model No. ILCP Spacing Plate Model No. ILC246

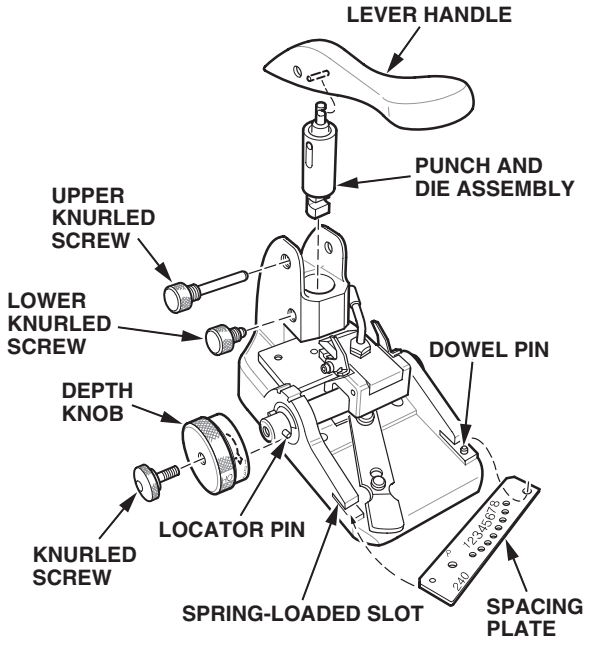
* Kits C and D require Punch & Die Assembly (45°), included in Kit A.

BEFORE YOU START CUTTING

- Get the original key number and the vehicle model and model year from your customer.
- Get the applicable key blank. Refer to your *Honda Parts Reference Guide* for the Honda key blank part number. See **PARTS INFORMATION** for Ilco programmable key blank model number information.
- Determine which accessory kit you will need with the key cutter. Refer to the **APPLICATION CHART** for details.
- Look up the applicable 8-digit cutting code for the key number. Refer to Ilco Unican's *Key Codes For Honda Vehicles*, either No. ACB-HO in the tan 3-ring binder or No.158219 in the blue folder.

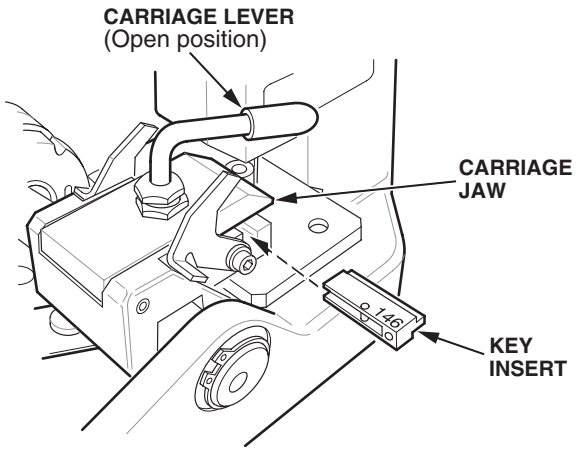
CUTTING PROCEDURE

1. Make sure the key cutter base is free of any metal debris.
2. Inspect the punch and die assembly, and replace it if it is worn. (The assembly is usually good for 2,000 cuts.)
3. Install the punch and die assembly, making sure the flat part on the assembly faces toward the front of the key cutter. Use the lower knurled screw to secure the assembly.



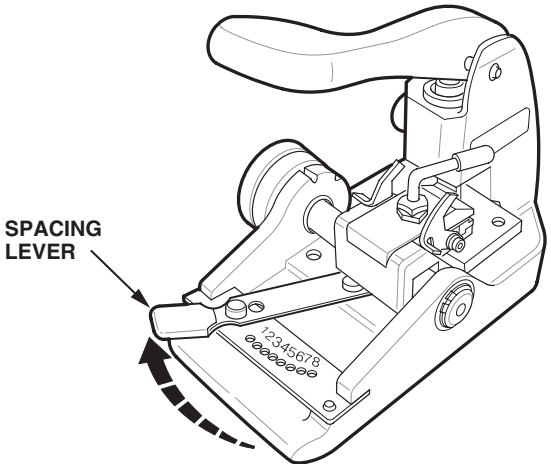
4. Install the lever handle, and use the upper knurled screw to secure it.
5. Anchor the spacing plate to the dowel pin on the right front of the key cutter, and pivot the other end of the plate into the spring-loaded slot.
6. Line up the machined slot on the depth knob with the locator pin on the shaft. Use the knurled screw to secure the knob to the shaft.

7. Turn the carriage lever counterclockwise to open the carriage jaw.

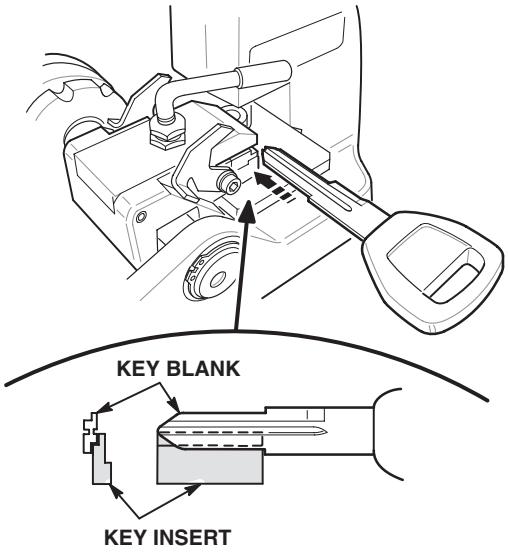


8. Slide the key insert, with its 3-digit number facing up, into the right side of the carriage jaw until the insert clicks into place. (For 1995–97 Passport models, slide the insert into the *left* side of the carriage jaw.)
9. Move the spacing lever to the **P** (Park) position on the spacing plate.

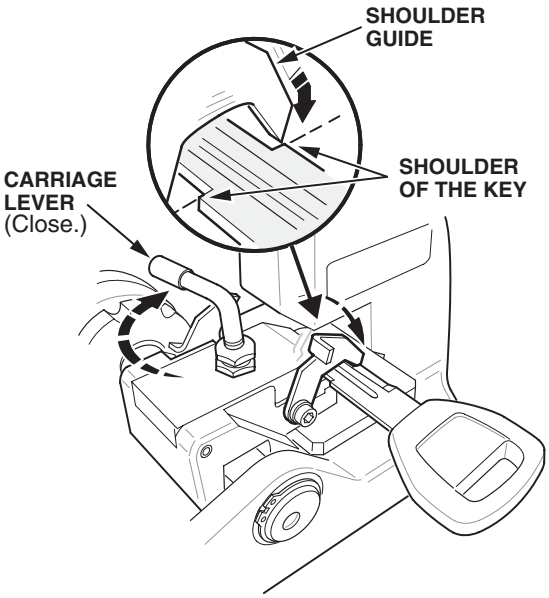
   NOTE: The spacing plate for Kit A does not have a park position. For Kit A, move the spacing lever to the far left of the plate.



10. Slide the key blank into the right side of the carriage jaw, making sure the grooves on the underside of the key blank mate with the edges of the key insert. (For 1995.5–97 Passport models, slide the key blank into the left side of the carriage jaw.)



11. While sliding the key blank into the carriage jaw, lower the right shoulder guide. (For 1995.5–97 Passport models, lower the *left* shoulder guide.) Keep sliding the key blank into the jaw until the shoulder of the key blank butts the shoulder guide.



12. Press the key blank firmly against the insert, and turn the carriage lever clockwise to close the carriage jaw. Raise the shoulder guide.
13. Turn the depth knob to **1**, move the spacing lever to **1** on the spacing plate, and gently push down on the lever handle. The punch should not hit the key blank.

14. Move the spacing lever to **8** on the spacing plate, and gently push down again on the lever handle. The punch should not hit the key blank.
    - If the punch hits the key blank with the spacing lever positioned to either **1** or **8**, recheck your setup.
    - If the punch does not hit the key blank, go to step 15.
15. Move the spacing lever to **1** on the spacing plate.

    NOTE: If you are using Kit B and you are reading the cutting code from the Ilco Unican code book in the tan 3-ring binder (No. ACB-HO), move the spacing lever to **8** instead of **1**. If you are reading the cutting code from the Ilco Unican code book in the blue folder (No. 158219), keep the spacing lever on **1**.
16. Set the depth knob to the first number in the cutting code (reading from left to right), and firmly push down on the lever handle.
17. Advance the spacing lever to the next numbered hole on the plate, set the depth knob to the second number in the cutting code, and firmly push down on the lever handle. Repeat this cutting process until you have completed all eight cuts on one side of the key blank.
18. Open the carriage jaw, and remove the key.
19. Turn over the key, and repeat steps 9 thru 18 to cut the other side of the key.
20. Use a small wire brush to smooth the cut surfaces on the key.